



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBST2120-5
Job Sheet 175962

APR 12 2018



Part No: RBST2120-5

Job Qty: 6 ea

DAS
13
9-89

Part Name: Roller



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/12/18

Job Tracking No:

Created By: Chantal Lavoie

Due Date: 4/12/18

Type: Stock

Description:

Note: RBST2100 REV.7 IPP REV:A 18.01.31 NEW ISSUE JFC VERF:DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Outsource	6 pcs	4/12/18	4/12/18			AEF001-VC Purchasing 7		18/04/18
110	Packaging	6 pcs	4/12/18	4/12/18	0.00	0.00	Packaging2		AT 18/04/18
120	QC	6 pcs	4/12/18	4/12/18	0.00	0.00	QC6		38
130	Packaging	6 pcs	4/12/18	4/12/18	0.00	0.00	Packaging3-2		18-04-13
140	QC21-SA	6 Ea	4/12/18	4/12/18	0.00	0.00	QC21		GA 13/04

Part Op 100 - ISSUE P/O: 39425 TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF
Descriptions: 89031009 39589

APR 12 2018

DAS 13 21 APR 1 2018
9-89 X to 23

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
89031009	Plug and Pin Gauge	3 Ea (.5 ea)	100-Outsource	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Outsource	89031009	3	39	0

Part Specifications

Specifications could not be found.



Container No: S060541



Part: RBST2120-5

Job No: 175962

Serial No/Batch: S060541

Revision: 7

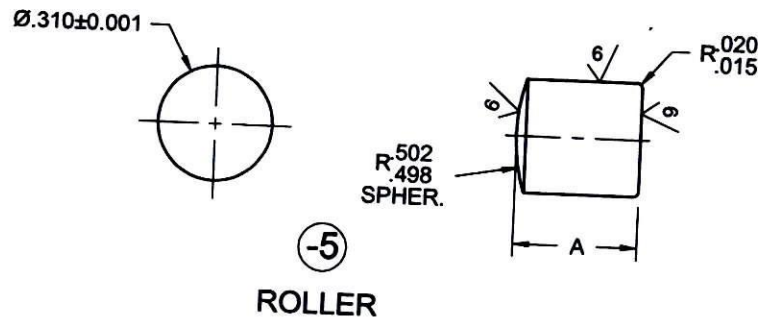
Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Plex 4/12/18 1:05 PM dart.lavoie.chantal

Date: 04/12/18

REVISIONS				
REV	DESCRIPTION	DATE	INITIAL	APPROVED
1	ADDED NOTE TO -1 BODY TO INSPECT BEFORE HEAT TREATING, ALSO CHANGED TOL., OF -1 ROLLER FIXTURE'S ØB, ØC, & ØE FROM +.002 -.000.	2/11/08	WP	DW
2	-18 CHD LOCATING PIN TOLERANCE FROM Ø.2480 Ø.2475 TO Ø.250 P.F. -11 & -13. -11 & -13 CHD FROM Ø.247 Ø.246 TO REAM Ø.290. REMOVED MS14102 & MS14104 CHAMFERED BEARINGS FROM LIST.	2/19/08	WP	GE
3	ADDED KST2128 & KST2162. -13 REMOVED 25° ANGLE FROM SECONDARY SEAT AND DELETED ØB DIMENSION. ADDED QTY TO -13 & -15 CHART.	4/22/08	WP	DW
4	-5 CHD ROLLER RADIUS FROM .005 - .010, TO .015 - .020. -9 PIN RADIUS FROM .015 MAX., TO .015 MIN. CHD -7 SLEEVE TO -7 GUIDE.	7/7/08	WP	DW
4A	CHD T/N FROM KST2100.	11/19/09	RJC	
5	CORRECTED ERROR -3 WAS .165 NOW .172 FOR ROLLER CLEARANCE. ADDED REVISIONS TO ALL PAGES.	1/18/10	WP	DW



TOOL #	A +.001 -.001	MATERIAL		
RBST2120	.335	.310 MINUS	GAUGE PIN	MSC#89031009
RBST2128	.335	.310 MINUS	GAUGE PIN	MSC#89031009
RBST2162	.335	.310 MINUS	GAUGE PIN	MSC#89031009

RED BARN MACHINE	
TITLE RBST2100 SERIES TRI-ROLLER SWAGING TOOL; ROLLER (QTY. 3)	
DWG NO.	TOOL# (see chart)-5
REV 7	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS XXX ± .005 .XX ± .01 X ± .1	FRACTIONS ± 1/32 ANGLES ± 5°
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR .015 R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
SCALE NTS	DATE 1-23-08
SHEET 4 of 9	
DRAWN BY: PERRITT APPROVED: <i>[Signature]</i> HEAT TREAT RC 55-60 FINISH SPEC USED ON BEARING SEE Pg. 1	



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER **PO039589**

Supplier: AFF001-VC
Affutage K.G. Inc.
11455 Philippe Panneton Ave.
Montreal
QC
H1E 4M1 Canada
Phone: 514 323 0192 514 323 6631
Fax: 514 323 6631

PO No: PO039589
PO Date: 4/12/18
Due Date: 4/12/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lavoie, Chantal
Phone: clavoie@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments: ref. po039485

Items

Line Item	Part	Supplier Part No	Description	Status	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	RBST2120-5		Roller ISSUE P/O: _____ TO KG GRINDING. MANUFACTURE AS PER DWG. SHIP QTY REQUIRED OF 89031009 WO 175962	Firmed	4/12/18	23 pcs	0 pcs 23x	23 pcs	\$12.00/pcs	\$276.00

Grand Total: \$276.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 4/12/18 1:41 PM dart.lavoie.chantal

CL

AFFUTAGE K.G. INC.
K.G. GRINDING INC.

40 ans
Depuis 1975

**11455 Ave. Philippe Panneton
Montréal, Québec
Canada, H1E 4M1
Tél. : 514-323-0192
Fax : 514-323-6631**

Distributeur d'outils de coupe & Affutage sur mesure

Distributor of cutting tools & Custom tooling

BON DE LIVRAISON
DELIVERY SLIP

DART AEROSPACE

DATE: April-9-2018

73147

P.O.# 039485

[illegible]

REÇU EN BONNE CONDITION / RECEIVED IN GOOD ORDER

www.kggrinding.com • sales@kggrinding.com